

Work Order ID 83123-1

April-13-12 7:31:40 AM

\*83123\*

Page 1

Item ID: D4617-7

Revision ID:

Item Name: Clamp Half

Start Date: 13/04/2012 Start Qty: 1.00

Required Date: 20/04/2012 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

QC:

Date: 12/04/13

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4617

100

Cut blanks as per folio

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

110

0.00

\*110\*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO

FOLIO REV: AA

DWG REV: A

DEBURR

cut 12/04/14

34

B.a 12/04/17

4

AS AP

1/34/13

MCJ

\*1\*

\*1\*

\*N9000040100\*

Cust Item ID:

Customer:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83123

April-13-12 7:31:40 AM

**\*83123\***

Page 2

Item ID: D4617-7

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Start Date: 13/04/2012 Start Qty: 1.00

Required Date: 20/04/2012 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

**\*NR1\***

Stop

**\*NR2\***

**\*N900040100\***

Setup

Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*D.P. 12/04/17*

*4 0*

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

*4 0*

*SG 12/04/18*

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

*(4) 266 12-4-18*



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 83123

\*83123\*

Page 3

April-13-12 7:31:40 AM

Item ID: D4617-7

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Clamp Half

Start Date: 13/04/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

\*150\*

QC

Memo

0.00

Quality Control

4X

✓

M-L  
12/04/18

160

Identify as per dwg & Stock Location: BA

0.00

\*160\*

Packaging

Memo

0.00

Packaging

(4)

S  
12/04/19

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Memo

0.00

Quality Control

12/4/19

12-04-18

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

April-13-12 7:31:45 AM

Page 1

Work Order ID: 83123

\*83123\*

Parent Item: D4617-7

\*D4617-7\*

Parent Item Name: Clamp Half

Start Date: 13/04/2012

Required Date: 20/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV: A NEW ISSUE 12-04-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.625X01.50 0		Purchased	No				f	18.5600		0.166316			

\*M6061T6B0 625X01 500\*

\*\*

6061-T6 Bar .625 x 1.50

Location

Loc Qty

Loc Code

MAT002

18.56

115111

18.56

5.86 on 12/04/14



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & Initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP

D4617-045  
CLAMP ASSEMBLY  
4 PL

D4618-041  
CLAMP ASSY COVER  
4 PL  
(SHOWN REMOVED THIS LOCATION)

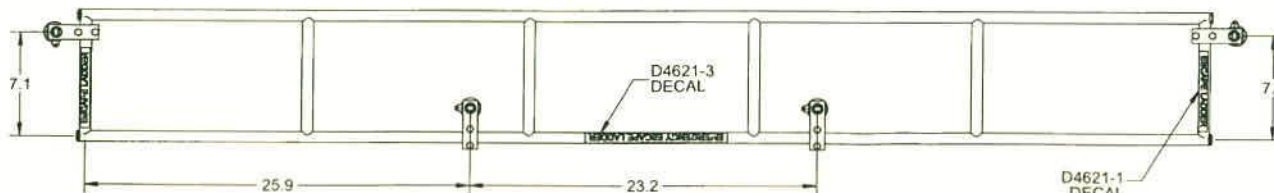
D4617-043  
LADDER WELDMENT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 83123  
MLC  
12/04/13

D4625-1  
TUBE CAP  
4 PL

(CLAMP ASSY COVERS REMOVED FOR CLARITY)



D4621-1  
DECAL  
2 PL

### D4617-041 EMERGENCY ESCAPE LADDER

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
- 7) WEIGHT: 6.46 lbs

REV	NEW ISSUE	DESCRIPTION	RP	12.04.02
DESIGN	RP		BY	DATE
DRAWN	RP			
CHECKED	AD			
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.04.02			

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A  
D4617 SHEET 1 OF 5  
TITLE SCALE  
EMERGENCY ESCAPE LADDER NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

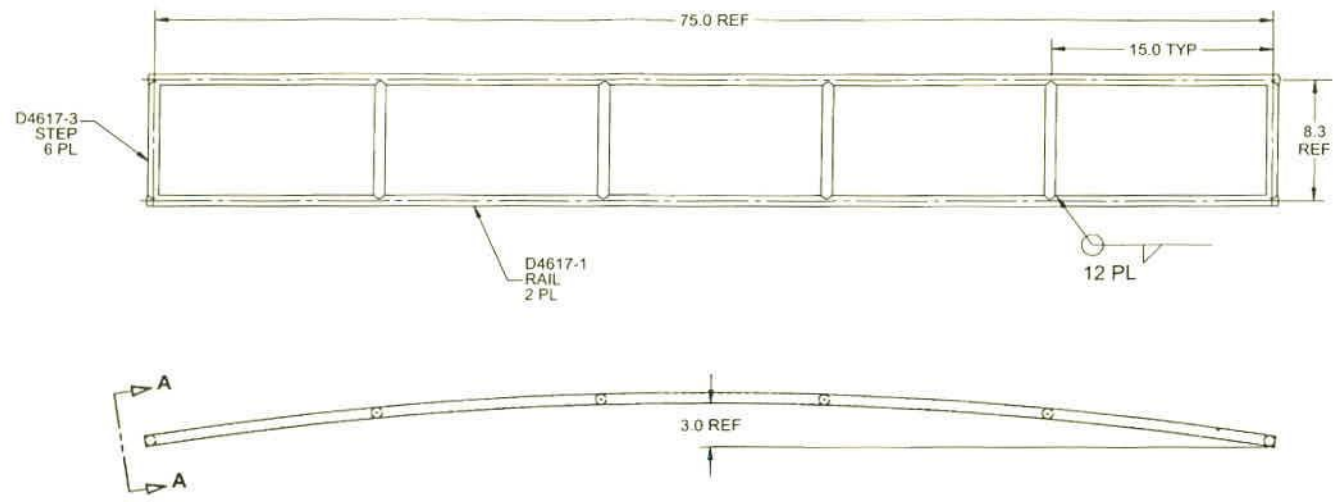
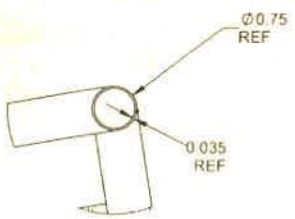
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

03123



**D4617-043 LADDER WELDMENT**

RELEASED  
2012-04-10

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 4.5 lbs
- 8) WELDING: PER DART QSI 004

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MFG. APPR.	BE	D4617	SHEET 2 OF 5
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

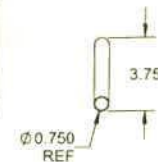
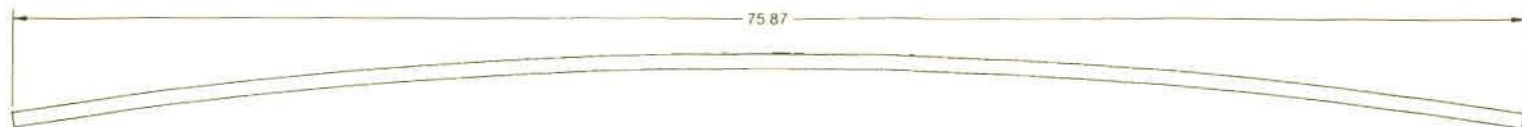
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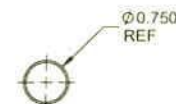
**NOTE:** Date & initial all entries



03123



**D4617-1 RAIL**



**D4617-3 STEP**

RELEASED  
2012-04-18

**NOTES:**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T6736  
OR AMS6371, 6360, 6361, 6362, 6373, 6374  
REF DART SPEC M4130NT0.750W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: D4617-1 1.7lbs  
D4617-3 0.17lbs

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.R.	DRAWING NO.	REV. A
MFG. APPR.		D4617	SHEET 3 OF 5
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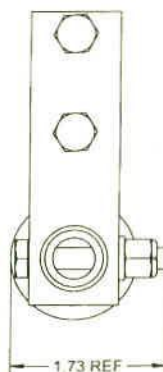
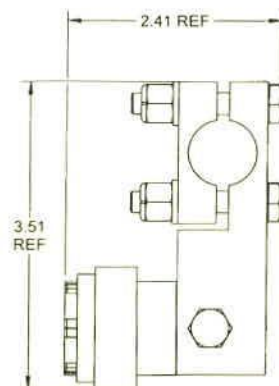
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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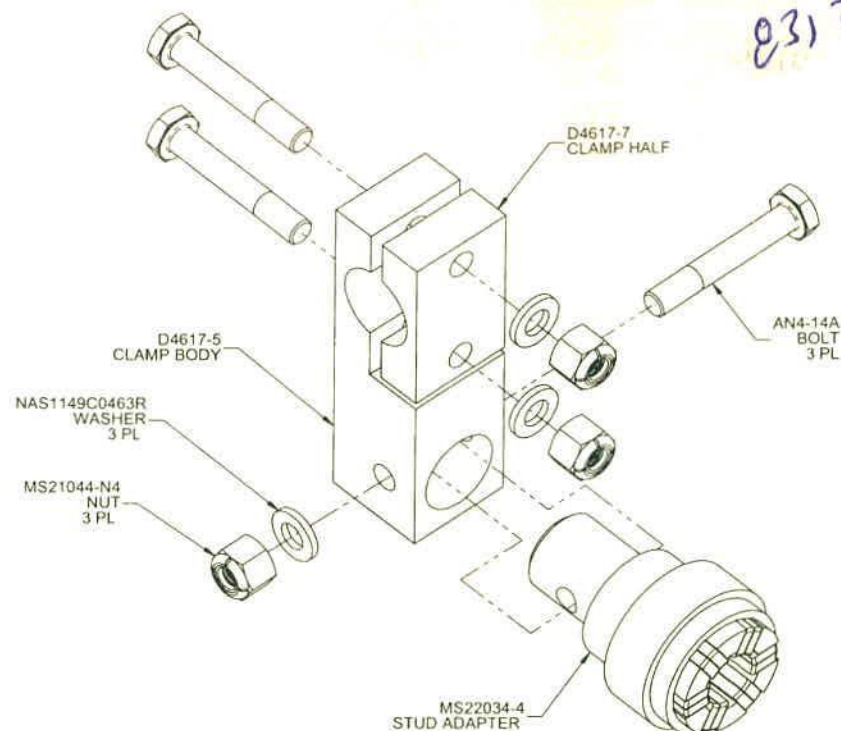
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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-045	CLAMP ASSEMBLY
1	1	D4617-5	CLAMP BODY
2	1	D4617-7	CLAMP HALF
3	3	AN4-14A	BOLT
4	3	MS21044-N4	NUT
5	1	MS22034-4	STUD ADAPTER
6	3	NAS1149C0463R	WASHER



**D4617-045 CLAMP ASSY**



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 0.5 lbs

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED	RP	DRAWING NO.	REV. A
MFG. APPR	RP	D4617	SHEET 4 OF 5
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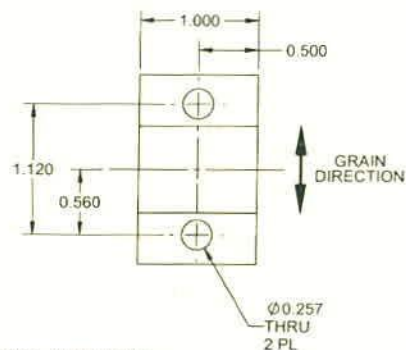
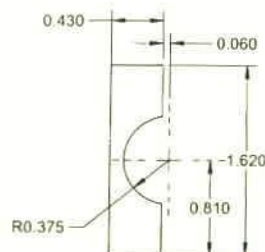
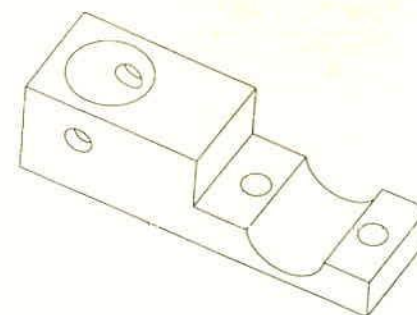
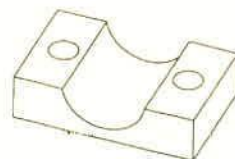
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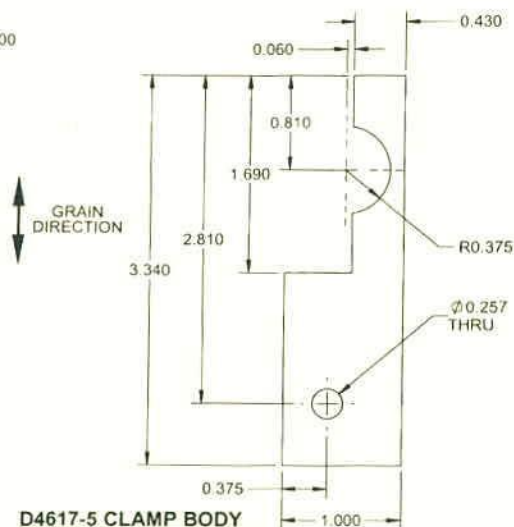
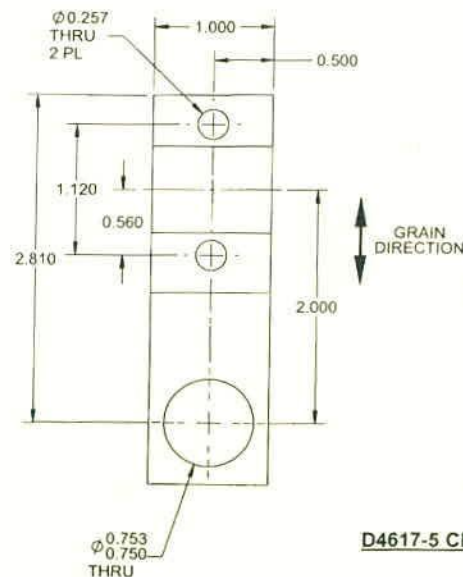
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83123



**D4617-7 CLAMP HALF**



**D4617-5 CLAMP BODY**

**NOTES**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR  
AMS 4117/4128/4115/4116 OR QQ-A-200/8  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: D4617-5 0.17 lbs  
D4617-7 0.05 lbs
- 8) POSSIBLE SUPPLIER: D4617-5: EAGLE P/N 212-110-06  
D4617-7: EAGLE P/N 212-110-07

RELEASE  
2012-04-10

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED		DRAWING NO. <b>D4617</b>	REV. A
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		SCALE	
DE APPR.		EMERGENCY ESCAPE LADDER	
DATE	12.04.02	NTS	

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